Garant

Machine tap for synchronised spindles HSS-E-PM Form C, TiAlN, M: M5

Order data

Order number	135410 M5
GTIN	4045197446305
Item class	11H

Description

Version:
Sturdy version with right-hand helix and shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives.** The tap is guided by the synchronised spindle on the machine. Special **TiAlN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).
Recommendation:
For **TOOLOX materials** we recommend **deviating from the DIN** data (see table) by drilling the tapping hole ∅ **0.05 to 0.3mm** larger.
Note:
For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.
Thread type: M
Tool material: HSS E PM
Standard: Manufacturer's standard
Tolerance class: ISO 2X 6HX
Thread pitch: 0.8 mm
Overall length L: 70 mm
Shank ∅ D_s: 6 mm
Shank square □: 4.9 mm
Tapping hole ∅: 4.2 mm

Technical description

Thread ∅	5 mm
Number of cutting edges Z	3
Tapping hole ∅	4.2 mm

Number of clamping slots	3
Thread pitch	0.8 mm
Standard	Manufacturer's standard
Shank ⌀ D_s	6 mm
Overall length L	70 mm
Shank square ☐	4.9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	12.5 mm
Thread type	M
Thread size	M5
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 °
Shank	DIN 1835 B to h6
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm²	suitable	32 m/min	P

Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
Steel < 1400 N/mm²	suitable	7 m/min	P
TOOLOX 33	suitable	7 m/min	H
TOOLOX 44	suitable only under restricted conditions	3 m/min	H
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		